

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.22P.B**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000296**Date Inspected:** 11-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:**Index Lot #:** B72-041-07**Witness Lot #:** B26-013-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhang Xing Jin**ID #:** N/A**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-2231

N/A

Base Metal: A709-50F-2

N/A

PQR ID #: HP2007225

N/A

Thickness: 26 millimeters

N/A

Process: FCAW

N/A

Electrode Spec/Class: AWS A5.20/E71T1-1

N/A

Positions: Flat (1G)

N/A

Backing Material: A709-50F-2

N/A

CWI: Wei Huang

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: Paragraph 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

PQR Test Plate HP2007225- The Caltrans QA Inspector observed that the presented radiographs for this PQR test plate contain linear indications that are not in compliance with the requirements of AWS D1.5 (2002). It is inconclusive as to whether or not the PQR test plate weld cap with multiple weld passes represents the linear indications within the radiographs. The Caltrans QA Inspector and ZPMC representative Mr. Lu Jian Hua visually observed that the PQR test plate weld cap had not been ground flush prior to radiographic testing. Mr. Lu Jian Hua stated that the weld cap needed to be ground and subsequently radiographically tested again. Radiographic film reviewers for ZPMC and ABF representative Mr. Nate Lindell did not address this issue prior to this review by the Caltrans QA Inspector. The Caltrans QA Inspector included a digital picture of the PQR test plate which contains the unground weld cap. This digital picture is included within a Caltrans 6031 for this date.

Summary of Conversations:

As identified within the contents of this report.

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is in general conformance with the contract requirements.

Observed welding,testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Cuellar,Robert

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer